



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4314-1

Job Sheet 172972



Part No: D4314-1

Job Qty: 20 ea

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		3/3/18	0.00	0.00	Start Up Waterjet		SC 8/04/07
100	Waterjet	20 pcs		3/3/18	0.02	1.05	Waterjet1		SC 8/04/07
120	QC	20 pcs		3/3/18	0.00	0.00	QC8		3/5
130	Small Fab	20 pcs		3/3/18	0.00	0.47	Small Fab-6		3/5
150	QC	20 pcs		3/3/18	0.00	0.00	QC5		3/5
160	HandFinish	20 pcs		3/5/18	0.00	0.57	HandFinish1		SAD 04-08
170	QC	20 pcs		3/5/18	0.00	0.00	QC7-3		11 APR 11 2018
180	Packaging	20 pcs		3/5/18	0.00	0.00	Packaging3-2		9-APR 11 2018
190	QC21-SA	20 Ea		3/5/18	0.00	0.00	QC21		9-80 DAS 21 9-80 APR 12 2018

Part Op 100 - 1-Cut as per Dwg D4314
Descriptions: 130 - COUNTER SINK AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	.3800 sf (.019 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	0	174	0



Container No: S057130



Part: D4314-1

Job No: 172972

Serial No/Batch: S057130

Revision:

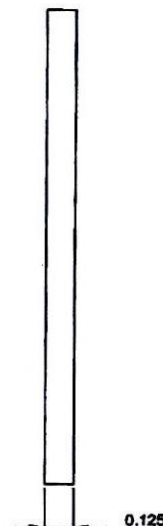
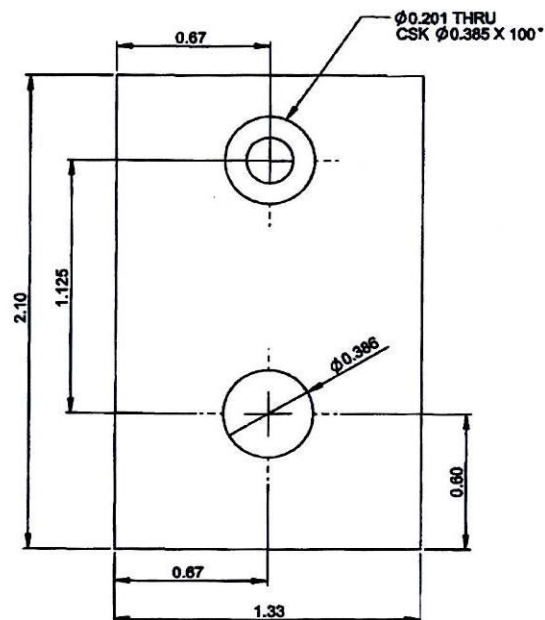
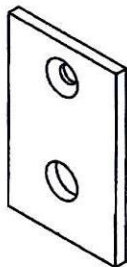
Inspector:

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CANADA
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www.dartaerospace.com

Date: 04/01/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim	0.201Inches + 0.005 - 0.001	0.206 0.200	0,202	Diameter
2	Shim	0.386Inches + 0.006 - 0.001	0.392 0.385	0,388	Diameter
3	Shim	0.670Inches ± 0.030	0.700 0.640	0,471	
4	Shim	1.125Inches ± 0.010	1.135 1.115	1,124	
5	Shim	0.600Inches ± 0.030	0.630 0.570	0,603	
6	Shim	2.100Inches ± 0.030	2.130 2.070	2,103	
7	Shim	1.330Inches ± 0.030	1.360 1.300	1,334	
8	Shim	0.125Inches ± 0.010	0.135 0.115	0,123	

Plex 2/23/18 12:36 PM dart.logan.david



D4314-1 SHIM

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125) OR ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.125) OR ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8 AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

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WORK ORDER

NO. 172972
20180226

RELEASED
2011-02-13
MB

A	NEW ISSUE		SC	11.01.13
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	SC			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4314	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		SHIM	NTS	
DATE	11.01.13			

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